

Tightening torques	Nm
Self-locking hex. nuts on lateral support of clamp	7
Self-locking hex. nut on exhaust flange to exhaust gas turbocharger	20–25
Self-locking hex. nut of exhaust pipe flange connection	20
Hex. screws of lateral support on transmission	20

Removal and installation of exhaust system is not described in full, reference will be made only to special, important points to which special attention must be paid during removal and installation or when renewing components, for example the end muffler with plug connection.

Removal

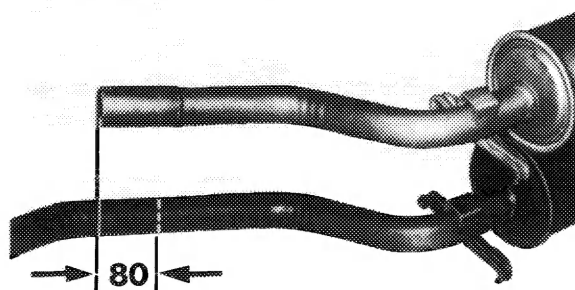
- 1 Check suspension members for re-use or renew, if required.
- 2 If a separation of plug connection between center and end muffler during repairs is impossible, heat exhaust pipe. For safety reasons, provide a protective shield on vehicle between frame floor and exhaust pipes prior to heating pipes.
- 3 Prior to mounting exhaust system, make sure that the flange to exhaust manifold is not distorted and align flange, if required. Clean cone connections of pipes and sintered sealing ring, if required, with emery cloth from combustion residue.

Installation

Replacement of end muffler.

- 4 Place new end muffler with plug connection accurately above removed assembly and mark pipe length of new end muffler similar to removed assembly.

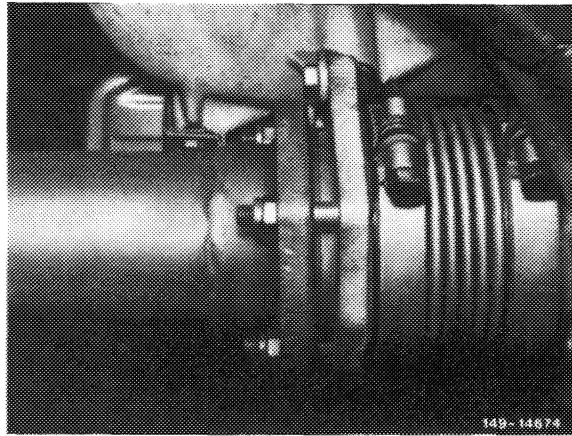
Separate pipe at a point 80 minus 10 mm from mark in direction of end muffler to provide a plug-in depth of 70–80 mm.



5 Always replace self-locking hex. nuts.

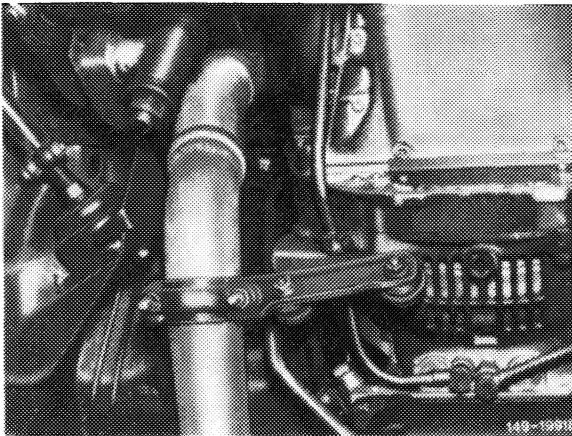
Connection exhaust pipe — exhaust turbocharger

6 Tighten flange connection to exhaust gas turbocharger only after the complete assembly has been suspended in rubber rings. Tightening torque of hex. nuts 20–25 Nm.



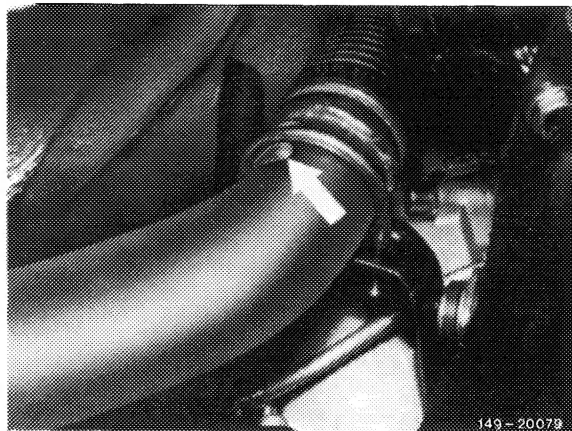
7 Mount rear exhaust assembly with center and end mufflers.

Note: The front exhaust pipe is provided with a rolled hose. Prior to connecting the rear exhaust assembly to front exhaust pipe, mount clamp of lateral support in a lightly tightened condition to relieve rolled hose.



Model 123.193

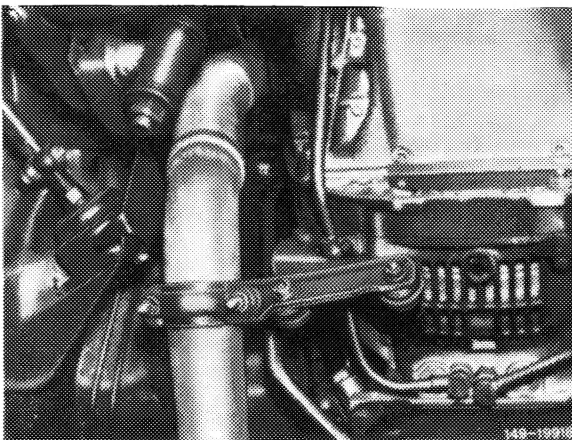
8 Clamp of front exhaust pipe should be mounted in such a manner that it is located between the two lugs on exhaust pipe (arrow).



Model 126.120

9 Mount exhaust lateral support free of tension. Tightening torque of self-locking hex. nuts on clamp 7 Nm, hex. bolts of lateral support on transmission 20 Nm.

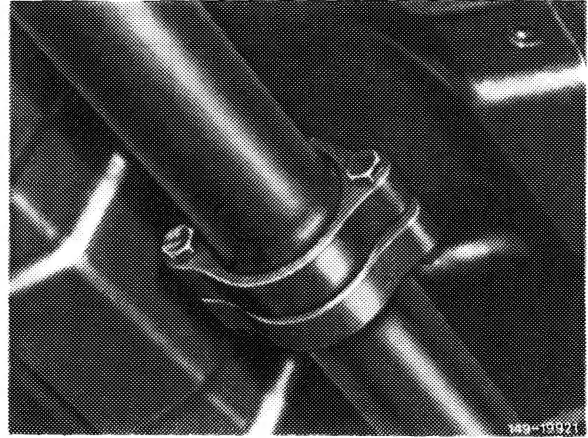
Note: Mount 4 cup springs each per side on holding bracket in such a manner that their crowns are each opposed to the other.



Model 123.193

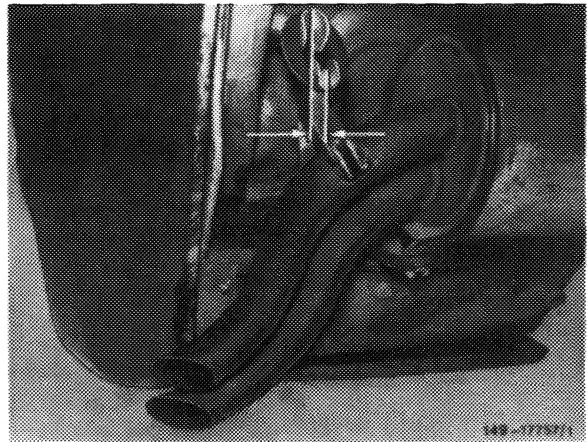
10 Mount sintered sealing ring on flange connection and pay attention to correct seat. Tightening torque of self-locking hex. nuts 20 Nm.

Model 126.120



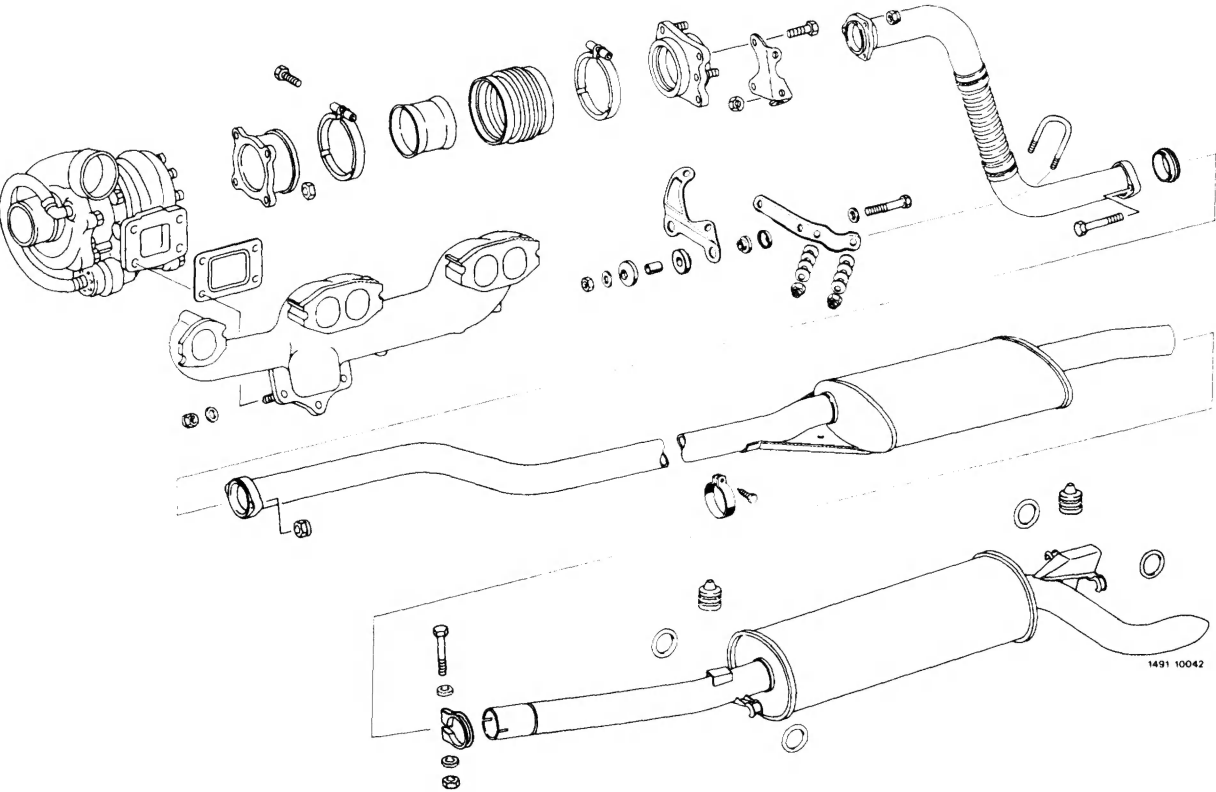
11 Mount end muffler in such a manner that the clamps of the end muffler are approx. 10 mm in front of holders on frame floor (arrows), so that in the event of an elongation of exhaust system the correct installation position is ensured.

Note: The checkup refers only to repair version mufflers with plug connection between center and end muffler.



12 Run engine and check exhaust system for leaks.

Exhaust manifold with exhaust gas turbocharger and complete exhaust system model 123.193



Exhaust manifold with exhaust gas turbocharger and complete exhaust system model 126.120

